

Work Order ID 124880

124880

Page 1

Thursday, September 25, 2014 1:07:02 PM

Item ID: D206-642-541 Accept *N900040100* Setup Start *NS1*
 Revision ID: U/R OK U/R 14/9/15 Stop *NS2*
 Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
 Tri-Bag Float Comp
 Start Date: 9/25/2014 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/25/2014 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: MLS Date: 14-09-25 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Draw Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3274-041	F								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D206-642-541								

N/A

Work Order ID 124880

124880

Page 2

Thursday, September 25, 2014 1:07:02 PM

Item ID: D206-642-541 Accept *N9000040100* Setup Start *NS1*
Revision ID: U/R
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical) Stop *NS2*
Tri-Bag Float Comp
Start Date: 9/25/2014 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 9/25/2014 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

VERIFY AND INSPECT THE MATERIAL PRIOR TO USE

1- remove fwd indexing ridge as per dwg D3274. Prepare for welding DGC 11-9-26

2- weld fwd cap as per dwg D3274 and QSI004
AR Aluminum Rod Batch: M125127

3- grind fwd cap weld on top surface only

4- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

5-Drill Aft cap pilot hole using DT8025

6 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274

7 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

8 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

76614-09-29

DGC 11-9-30

Thursday, September 25, 2014 1:07:02 PM

124880

Page 3

N900040100

Setup Start *NS1*

Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp

Stop *NS2*

Start Date: 9/25/2014 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 9/25/2014 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID
114

Operation	Description
QC5-	Inspect part completeness to step on W/O

Set Up/ Bus Hours	0.00
------------------------------	------

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
			DAS 9 9-89
	14	1001	

1 1 Δ

QC

Memo

0.00

Quality Control

116

QC10- Inspect visual per QSI004- ground welds

0.00

116

OC

Memo

0.00

Quality Control

① 14.10.01

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

2 0 14-10-01 DGL

Work Order ID 124880

124880

Page 4

Thursday, September 25, 2014 1:07:02 PM

Item ID: D206-642-541 Accept *N9000040100* Setup Start *NS1*
Revision ID: U/R Stop *NS2*
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp
Start Date: 9/25/2014 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 9/25/2014 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Down Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00							
130									
QC	Memo	0.00							
Quality Control									
150	Skidtubes	0.00							
150									
Skidtubes	Memo	0.00							
Skidtubes	1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274								
	2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube								
	3-Bond web in place as per Dwg D3274 & QSI 015.								
	A/RSikaflex-291 <u>129457</u>								
	Sikaflex expire date: <u>14-11-20</u>								
	Start: _____ Time: <u>7:20 AM</u>								
	Finish: _____ Time: _____								
	(Adhere for 12 hours)								

Work Order ID 124880

Thursday, September 25, 2014 1:07:02 PM

124880

Page 5

Item ID: D206-642-541 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: U/R Stop ***NS2***
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp
Start Date: 9/25/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/25/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170		0.00							
170	Skidtubes	0.00							
Skidtubes	Memo								
Skidtubes	1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.								
	2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Deburr								
	3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES								
	4- Countersink crossbolt spacer holes as per Dwg D3274								
	5- prepare for welding								

DAS
03
9-25

DP 14-10-3

DP 14-10-3

14-10-6

Work Order ID 124880

124880

Page 6

Thursday, September 25, 2014 1:07:02 PM

Item ID: D206-642-541 Accept *N900040100* Setup Start *NS1*
Revision ID: U/R Stop *NS2*
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp
Start Date: 9/25/2014 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 9/25/2014 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	DAS 18 9-29
180	QC5- Inspect part completeness to step on W/O	0.00	4.6"			1	0	14-10-07		

180

QC

Quality Control

Memo

190

190

Skidtubes

Skidtubes

Skidtubes

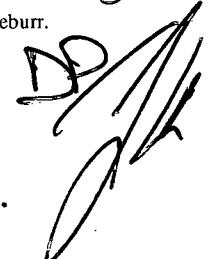
Memo

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod A/RAluminum Rod M125127

3-Grind cross bolt welds flush as per Dwg D3274.
****INSPECT FOR PIN HOLES IN WELD****

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

BE14-10-07

4-10-07


Work Order ID 124880

124880

Page 7

Thursday, September 25, 2014 1:07:02 PM

Item ID: D206-642-541 Accept *N900040100* Setup Start *NS1*
Revision ID: U/R Stop *NS2*
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical) Tri-Bag Float Comp
Start Date: 9/25/2014 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 9/25/2014 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
200						①	14-10-20		
QC	Memo	0.00							
Quality Control									
210	QC10- Inspect visual per QSI004- ground welds	0.00							DAS 9 9-89
210						①	14-10-20		
QC	Memo	0.00							
Quality Control									
220	Pressure Wash per QSI005 4.3	0.00							
220						①	14-10-22		
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch								

[Handwritten signature]

Work Order ID 124880

124880

Page 8

Thursday, September 25, 2014 1:07:02 PM

Item ID: D206-642-541 Accept *N900040100* Setup Start *NS1*
Revision ID: U/R Stop *NS2*
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp
Start Date: 9/25/2014 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 9/25/2014 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Down Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230		0.00							
230									
SprayPaint	Memo	0.00							
Spray Painting	Make sure Nut Plate Thread is protected using paint screw., 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>128 985</u> 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>129 977</u>								CR 14-1022
240	QC14- Inspect Spray Paint	0.00							
240									
QC	Memo	0.00							
Quality Control									
244	Wing Walk as per dwg QSI005 4.4 Batch <u>1013022050</u>	0.00							
244									
HandFinish	Memo	0.00							
Hand Finishing									

1x d of 14/10/27 15 9-89
1x d of 14/10/27

Work Order ID 124880

124880

Page 9

Thursday, September 25, 2014 1:07:02 PM

Item ID: D206-642-541 Accept *N900040100* Setup Start *NS1*
Revision ID: U/R Stop *NS2*
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp
Start Date: 9/25/2014 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 9/25/2014 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
246	QC3- Inspect Part Finish	0.00							DAS 38 9-29-14-10-27
246									
QC	Memo	0.00				1x			
Quality Control									
250		0.00							
250	HandFinishing								
HandFinish	Memo	0.00				1x	d	90	4/10/17
Hand Finishing									

1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.

A/RN/ALPS-PROCYON M122900

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/RSikaflex-291 M130277

Sikaflex expire date: 15108

Work Order ID 124880

124880

Page 10

Thursday, September 25, 2014 1:07:02 PM

Item ID: D206-642-541 Accept *N900040100* Setup Start *NS1*
Revision ID: U/R Stop *NS2*
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp
Start Date: 9/25/2014 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 9/25/2014 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC5- Inspect part completeness to step on W/O	0.00							
260									
QC	Memo	0.00							
Quality Control	Inspect Nut Plate & Inserts								
270		0.00							
270	HAND FINISHING RESOURCE #1								
HandFinish	Memo	0.00							
Hand Finishing	1-Install wearpads & gaskets as per Dwg D3274.								
	2-Install ring as per Dwg D3274								
	A/RSikaflex-291 11/13/27								
	Sikaflex expire date: 12/10/14								
	3-Inspect for foreign objects as per QSI 024								
	4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.								
	A/RSikaflex-291 11/13/27								
	Sikaflex expire date: 12/10/14								

1 0 14-10-24 0.29 34 9.89
1 0 11 11/10/27

Work Order ID 124880

124880

Page 11

Thursday, September 25, 2014 1:07:02 PM

Item ID: D206-642-541 Accept *N900040100* Setup Start *NS1*
Revision ID: U/R Stop *NS2*
Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical)
Tri-Bag Float Comp
Start Date: 9/25/2014 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 9/25/2014 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC5- Inspect part completeness to step on W/O	0.00				1			DAS 38 9-89
280									
QC	Memo	0.00							49 9-89
Quality Control									14/10/27
290	Identify as per dwg & Stock Location: _____	0.00							
290									
Packaging	Memo	0.00							DAS 06 9-89
Packaging									NOV 18 2014
300	QC21- Final Inspection - Work Order Release	0.00							
300									
QC	Memo	0.00							14/11/19
Quality Control									

W 14/11/19

Picklist Print

Thursday, September 25, 2014 1:07:04 PM

Page 1

Work Order ID: 124880

124880

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART (Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B05.09.23 Revised per D206-642 Rev. JKJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC IPP
 REV:H 13.09.05 CHG004/ ECN13-634 DD VRF:JLM IPP REV:I
 14.04.28 AS PER ECN14-520 DD VRF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3274-041BENT

Manufactured

No

110

Each

10.0000

1

1

D3274-041BENT

Skidtube Assembly 206

**

DGC 10-9-26

Location

Loc Qty

Loc Code

LG002

10

113682

1

120287

9

D4956-15

Manufactured

No

270

Each

14.0000

1

1

D4956-15

Stainless Steel Wearplate Fwd

**

10/10/23

Location

Loc Qty

Loc Code

FP002

14

120326

2

122996

12

D4956-23

Manufactured

No

270

Each

10.0000

1

1

D4956-23

Stainless Steel Wearplate Center Fwd

**

14/10/23

Location

Loc Qty

Loc Code

FP002

10

121755

10

XL

Picklist Print

Thursday, September 25, 2014 1:07:04 PM

Work Order ID: 124880

124880

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D4956-35 Manufactured No 270 Each 12.0000 1 1 Start Qty: 1.00 Required Qty: 1.00

D4956-35

Stainless Steel Wearplate Aft

**

11/10/27

Location	Loc Qty	Loc Code
FP002	12	
120577	1	
121975	11	

D4956-39 Manufactured No 270 Each 9.0000 1 1

D4956-39

Stainless Steel Wearplate Center Aft

**

11/10/27

Location	Loc Qty	Loc Code
FP002	9	
121857	9	

D3285-1 Manufactured No 110 Each 5.0000 1 1

D3285-1

Cap

**

BER-0929

Location	Loc Qty	Loc Code
LG001	5	
108052	5	

D3282-041 Manufactured No 150 Each 7.0000 1 1

D3282-041

Float Web (206L/407)

**

DGL 14-10-02

Location	Loc Qty	Loc Code
LG002	7	
113149	1	
119524	6	

Picklist Print

Thursday, September 25, 2014 1:07:05 PM

Page 3

Work Order ID: 124880

124880

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D2649 Manufactured No 190 Each 415.0000 12 12

Start Qty: 1.00

Required Qty: 1.00

D2649

Cross Bolt Spacer

**

BE14-10-06

Location	Loc Qty	Loc Code
LG	203	
123099	203	
LG001	212	
107906	3	
112728	6	
113811	2	
120508	195	
90497	6	

12

D3275-1 Manufactured No 190 Each 191.0000 12 12

D3275-1

Crossbolt Spacer

**

BE14-10-06

Location	Loc Qty	Loc Code
LG001	191	
113246	1	
113851	62	
114877	65	
121868	1	
121974	62	

12

CR3212-4-03 Purchased No 250 Each 998.0000 2 2

CR3212-4-03

Cherry Rivet

**

lll 11/10/21

Location	Loc Qty	Loc Code
ST321	998	
114889	1	
119017	700	
m114859	100	
m123265	197	

X1

Picklist Print

Thursday, September 25, 2014 1:07:05 PM

Page 4

Work Order ID: 124880

124880

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D3415-041

Manufactured No

250 Each

19.0000 1.00 1

Required Qty: 1.00

D3415-041

Nut Plate

**

ll 11/10/27

Location

Loc Qty

Loc Code

ST037

19

113764

19

x1

CCR264SS3-3

Purchased No

250 Each

431.0000 2

2

CCR264SS3-3

Cherry Rivet

**

ll 11/10/27

Location

Loc Qty

Loc Code

ST321

431

113973

26

m126282

47

m126333

70

m128636

88

m128818

200

x2

ALS4-1032-130

AEALS4-1032-130 Purchased

No

250 Each

4,073.000 78

78

ALS4-1032-130

Rivnut

**

ll 11/10/27

Location

Loc Qty

Loc Code

ST267

4073

M126109

57

M128211

48

M128649

3968

v78

Picklist Print

Thursday, September 25, 2014 1:07:05 PM

Work Order ID: 124880

124880

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D3537-3 Manufactured No

270 Each 60.0000 1 1

Start Qty: 1.00

Required Qty: 1.00

D3537-3

Wearpad

ll 10/10/22

Location	Loc Qty	Loc Code
FG	8	
86237	8	
FP001	12	
111825	1	
113789	1	
115122	10	
FP002	40	
120646	40	

x1

D3537-1 Manufactured No

270 Each 78.0000 9 9

D3537-1

Wearpad

ll 10/10/27

Location	Loc Qty	Loc Code
FG	18	
79833	8	
88562	10	
FP001	60	
113839	4	
120644	37	
120645	18	
93945	1	

B124485

x9

Picklist Print

Page 6

Thursday, September 25, 2014 1:07:05 PM

Work Order ID: 124880

124880

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

NAS1149C0332R

Purchased

No

270

Each

Start Qty: 1.00
8,181.000 80 80

Required Qty: 1.00

NAS1149C0332R

WASHER

**

all 10/10/27

Location

Loc Qty

Loc Code

CA	83	
m129682	83	
ST278	8098	
122063	41	
125654	473	
m126319	61	x80
m127306	2065	
m127410	166	
m127831	26	
m128591	75	
m129499	191	
m130325	5000	

NAS1149C0463R

Purchased

No

270

Each

622.0000 1 1

NAS1149C0463R

Washer

**

all 10/10/27

Location

Loc Qty

Loc Code

ST278	622	
119097	1	
123248	1	
123355	55	
m127306	125	11
m128401	440	

Thursday, September 25, 2014 1:07:05 PM

Shop Packet Print

Page 6

Thursday, September 25, 2014 1:07:05 PM

124880

D206-642-541

Required Date: 9/25/2014

Required Qty: 1.00

D3672-1

Washer, Phenolic

all who

Loc Code

10

10

945

4

474

421

34

12

1,103.000	80	80
-----------	----	----

AN3C4A

Bolt

III 11/10/25

Loc Code

20

20

1083

12

1

62

32

8

4

71

893

YBC

Picklist Print

Thursday, September 25, 2014 1:07:05 PM

Page 8

Work Order ID: 124880

124880

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

AN4C5A

Purchased

No

270

Each

56.0000

Start Qty: 1.00

1

1

Required Qty: 1.00

AN4C5A

Bolt

**

lll 11/10/12

Location

Loc Qty

Loc Code

ST355

56

122599

3

123265

1

M127410

10

M128403

42

X1

D2646

Manufactured

No

270

Each

57.0000

1

1

D2646

Aft Cap

**

lll 14/10/12

Location

Loc Qty

Loc Code

FG

4

85848

2

90495

2

FP001

12

103306

2

107857

1

110816

1

113830

2

114495

6

FP002

41

119656

41

X1

Picklist Print

Thursday, September 25, 2014 1:07:05 PM

Page 9

Work Order ID: 124880

124880

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube, High Gear, Standard Wearplates Fits LH or RH, DART
(Apical) Tri-Bag Float Comp

Start Date: 9/25/2014

Required Date: 9/25/2014

D3413-1

Manufactured No

270

Each

33.0000

Start Qty: 1.00

Required Qty: 1.00

1 1

D3413-1

O-Ring

ll 14/10/27

Location

Loc Qty

Loc Code

ST525

33

106048

1

110715

11

112309

6

114489

3

114528

1

116664

1

120218

10

xl

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2800-1-240	EXTRUSION
1	1	D2848	AFT CAP
12	12	D2848	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D4856-15	WEARSHOE
1	1	D4856-23	WEARSHOE
1	1	D4856-35	WEARSHOE
1	1	D4856-39	WEARSHOE
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN80C418	WASHER
80	80	AN80C10L	WASHER
2	2	CCR284SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

1. MATERIAL: N/A
2. FINISH: - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3282-041 WEB
- PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
- BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART QSI 005 4.4
3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
4. UNITS: INCHES UNLESS OTHERWISE NOTED
5. BREAK SHARP EDGES 0.005 TO 0.010 MAX
6. IDENTIFICATION: N/A
7. WEIGHT: 20.8 LBS
8. WELDING TO BE DONE PER DART QSI 004.
9. ALL HOLES DRILLED ON CENTERLINES.
10. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
11. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/281 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
12. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/281.
13. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS GREASE WITH WASH 'N WIPE DEGREASER.

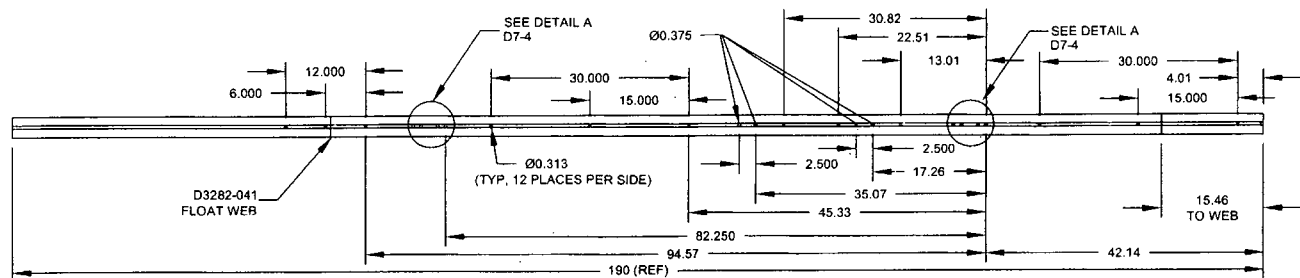


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 124 880 MJS

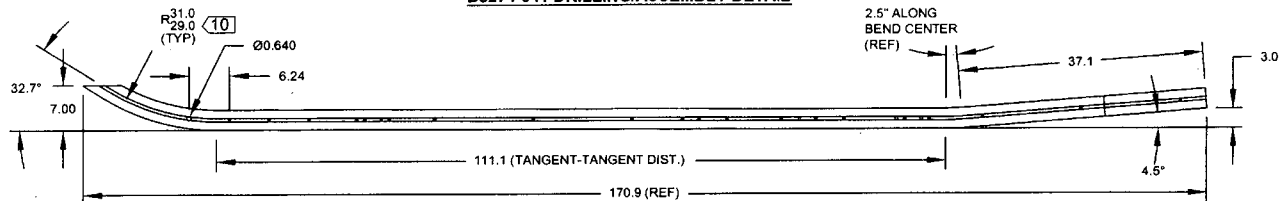
1409-25

RELEASED
2014-05-26
MD

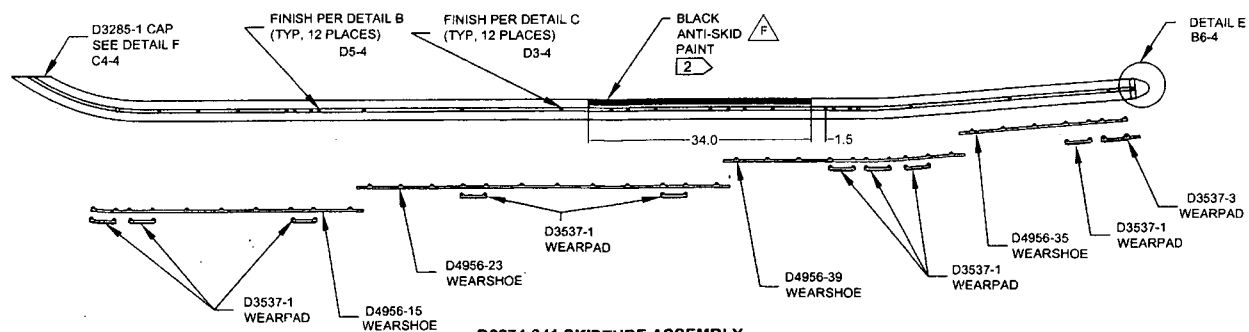
F	REVISE NOTE 2: ADD ANTI-SKID PAINT, REMOVE GASKETS PER IIN-D208-842 REV Q	DB	14.04.15
E	REVISE NOTE 2: FINISH NOW PRIME/PAINT WAS POWDERCOAT, REF. PAR13-256	DW	13.05.17
D	NEW INSERTS, SS WEARSHOE + GASKET	CP	06.12.19
C	ADD -043; NEW INSERTS	CP	05.03.18
B	MOVE SADDLE HOLE: 42.14 WAS 42.76	CP	04.08.09
A	NEW ISSUE	CP	04.03.15
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DB	KENT, WA	
CHECKED	MD	DRAWING NO.	REV. F
MFG. APPR.	MD	D3274	SHEET 1 OF 4
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	SKIDTUBE ASSEMBLY	NTS
DATE	14.04.15	COPYRIGHT ©2004 BY DART AEROSPACE USA, LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR CONVEYED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD.	



D3274-041 DRILLING/ASSEMBLY DETAIL



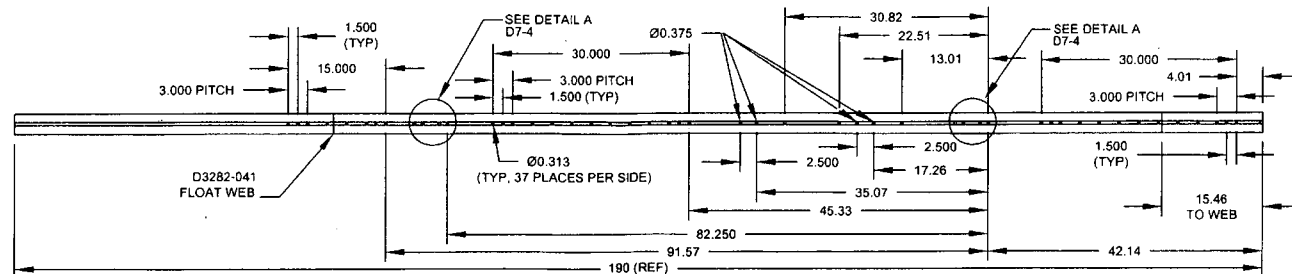
D3274-041 BEND/DRILLING DETAIL



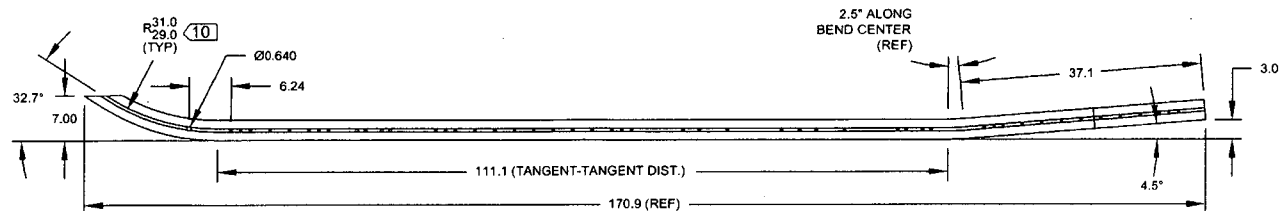
**D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

RELEASED
2014-05-26

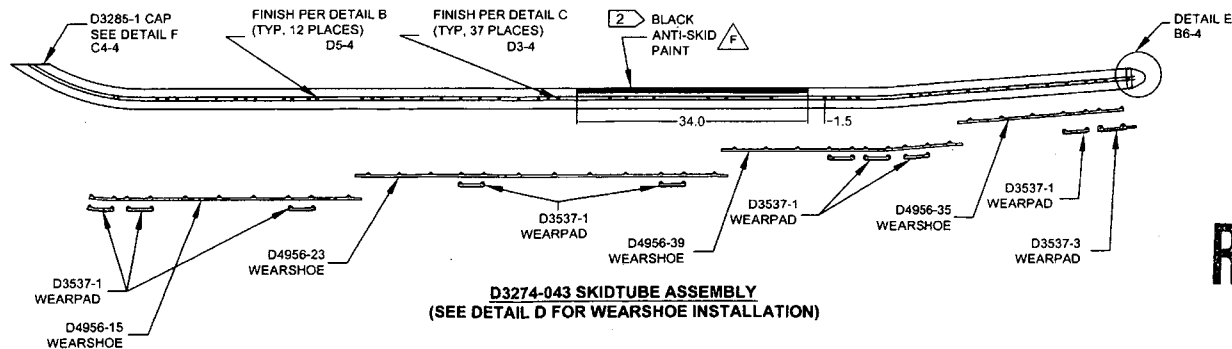
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DB	KENT, WA	
CHECKED	<i>DW</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3274	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE ASSEMBLY	NTS
DATE	14.04.15	<small>COPYRIGHT ©2004 BY DART AEROSPACE USA, LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD.</small>	



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL

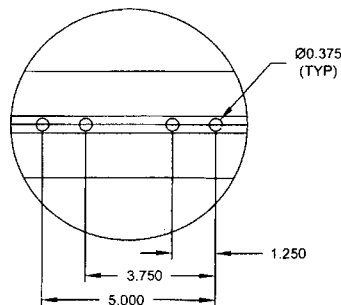


**D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

RELEASED
2014-05-26

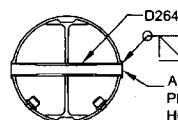
DESIGN	CP	DART AEROSPACE LTD	
DRAWN	DB	KENT, WA	
CHECKED	<i>De</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3274	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE ASSEMBLY	4.04.15
DATE	14.04.15	<small>COPYRIGHT ©2004 BY DART AEROSPACE USA, LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA LTD</small>	

DETAIL A: DRILL DETAIL
D6-2, D3-2, D5-3, D3-3



DETAIL B
B6-2, B5-3

FOR Ø0.375 HOLES ONLY

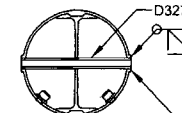


D2649 SPACER

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL C
B5-2, B4-3

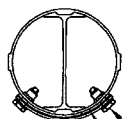
FOR Ø0.313 HOLES ONLY



D3275-1 SPACER

CHAMFER 0.030x45°
(TYP)

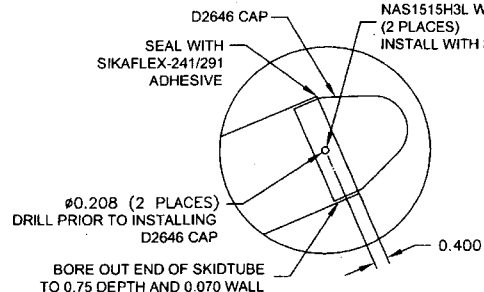
DETAIL D
A4-2, A4-3



ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E
B2-2, B2-3

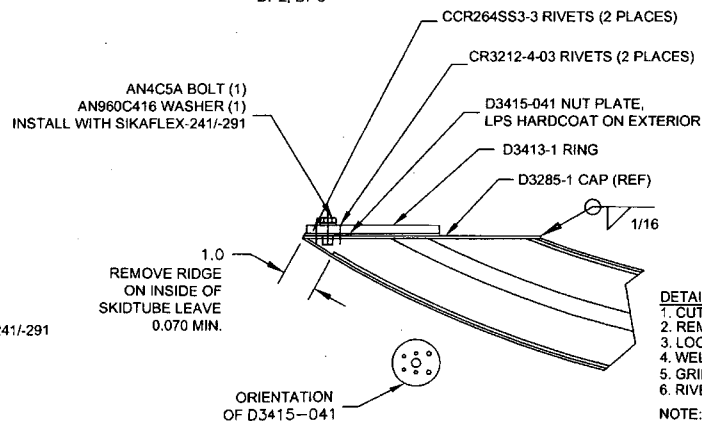


AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291

D2646 CAP

SEAL WITH
SIKAFLEX-241/291
ADHESIVE

DETAIL F: END FINISHING DETAIL
B7-2, B7-3



DETAIL F NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

RELEASE
2014-05-26

DESIGN	CP	DART AEROSPACE LTD KENT, WA	
DRAWN	DB		
CHECKED	g.p.	DRAWING NO.	REV. F
MFG. APPR.		D3274	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	14.04.15	COPYRIGHT ©2004 BY DART AEROSPACE USA, LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, LTD.	